

Work Order ID 74508

Monday, October 03, 2011 2:36:21 PM



Page 1

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: H.C.J.

Date: 11/10/03

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3535 | Rev B | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

B11-10-09

B11-10-07

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-07

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11 10 31 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130



Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-23

SB 11/11/01

13

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11 - 11 - 01 13

150



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

3200F

3:45

4:15

13X6M 11/11/01

W118439

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 74508

Monday, October 03, 2011 2:36:21 PM



Page 3

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | 13 | BL 11-11-2. | | |
| 170 | Identify as per dwg & Stock Location <u>F21</u> | 0.00 | | | | | | | |
| Packaging Packaging | Memo | 0.00 | | | | 13 | BL 11-11-2. | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | 11/11/02 |

11-11-02
(13)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 2:36:26 PM

Page 1

Work Order ID: 74508

Parent Item: D3535-23

Parent Item Name: Wearshoe



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|-----------|----|--|--|-----|----|----------|--------|----------|--|--|--|
| M304S20GA | | Purchased | No | | | 100 | sf | 170.5795 | 1.3615 | 17.19789 | | | |
|-----------|--|-----------|----|--|--|-----|----|----------|--------|----------|--|--|--|



304/316 .040 Sheet



BIT-10-28

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

83

119346

119346

12

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|--|--|---------------------|----------|
| DART AEROSPACE LTD | | Work Order: | 74508 |
| Description: Wearshoe | | Part Number: | D3535-23 |
| Inspection Dwg: D3535 Rev: B | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.885 | +/-0.010 | 1.887 | L | | U | |
| 2.000 | +/-0.010 | 2.000 | x | | U | |
| 4.750 | +/-0.010 | 4.756 | L | | T | |
| 9.500 | +/-0.010 | 9.506 | L | | T | |
| 14.250 | +/-0.010 | 14.256 | L | | T | |
| 17.750 | +/-0.010 | 17.756 | L | | T | |
| 23.140 | +/-0.010 | 23.146 | L | | T | |
| 28.530 | +/-0.010 | 28.536 | L | | T | |
| 33.920 | +/-0.010 | 33.926 | L | | T | |
| 39.310 | +/-0.010 | 39.316 | L | | T | |
| 44.700 | +/-0.010 | 44.706 | L | | T | |
| 48.200 | +/-0.010 | 48.206 | L | | T | |
| 52.850 | +/-0.010 | 52.856 | L | | T | |
| Ø0.188 | +0.005/-0.001 | .191 | L | | U | |
| 48.00 | +/-0.030 | 48.00 | L | | T | |
| 39.00 | +/-0.030 | 39.00 | L | | T | |
| 32.00 | +/-0.030 | 32.00 | L | | T | |
| 24.00 | +/-0.030 | 24.00 | L | | T | |
| 16.00 | +/-0.030 | 16.00 | L | | T | |
| 8.00 | +/-0.030 | 8.00 | L | | T | |
| 6.00 | +/-0.030 | 6.00 | L | | T | |
| 0.300 | +/-0.010 | .300 | L | | U | |
| 0.300 | +/-0.010 | .304 | L | | U | |
| 0.038 | +/-0.010 | .036 | x | | U | |

| | | | |
|------------------------|--------------------------------|----------------------------|-----|
| Measured by: RB | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 11-10-27 | Date: 11-10-31 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 07.11.23 | New Issue | KJ/EC/DD | [Signature] |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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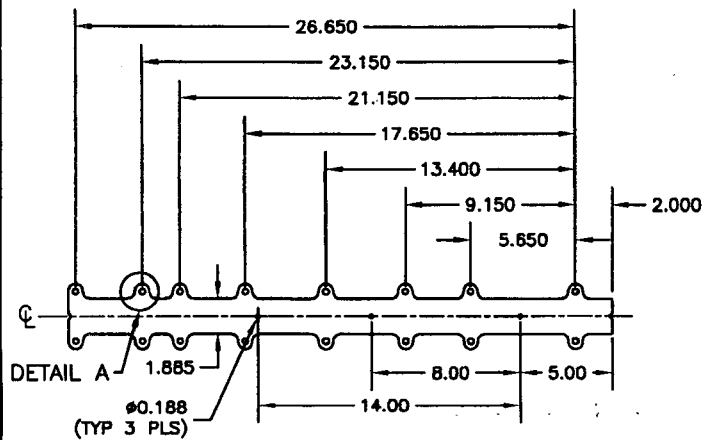
NOTE: Date & initial all entries

DART

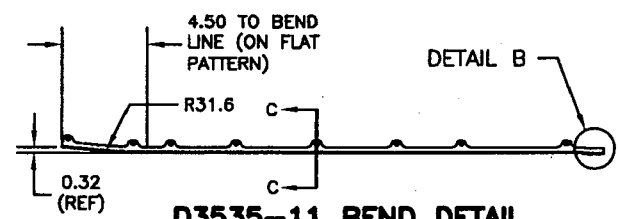
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07.04.24

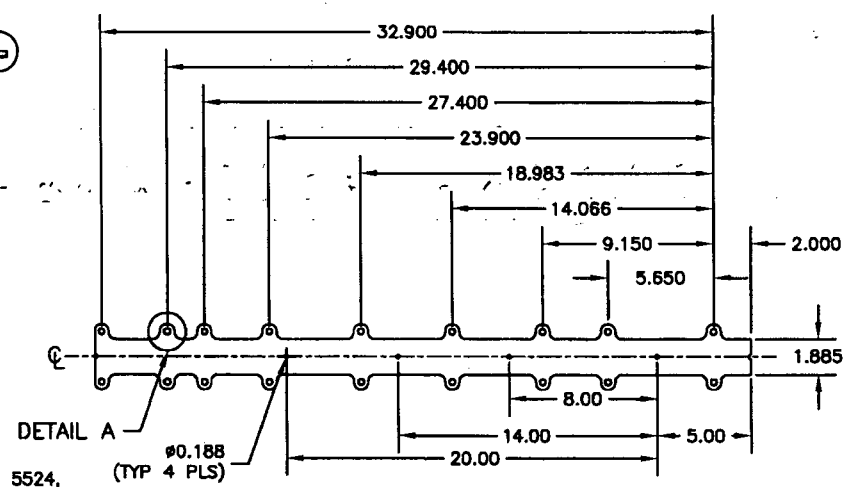
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74508 M.L.J
11/10/03



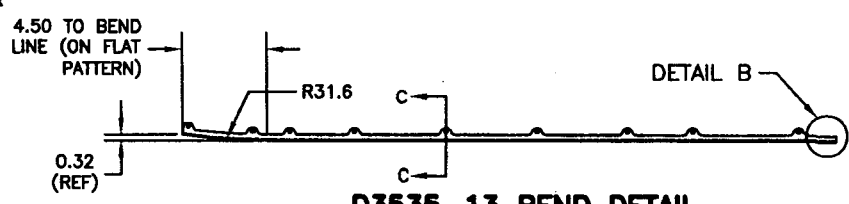
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|----------|----------|---------------------------------|
| C.B. | M. | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. |
| | | D3535 |
| DATE | TITLE | REV. B |
| 07.04.17 | WEARSHOE | SHEET 1 OF 7 |
| | | SCALE |
| | | 1:10 |
| A | 06.10.25 | NEW ISSUE |
| B | 07.04.17 | MOVE TAB OUTBOARD, ADD AMS SPEC |

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| W/O: | | WORK ORDER CHANGES | | | | | |
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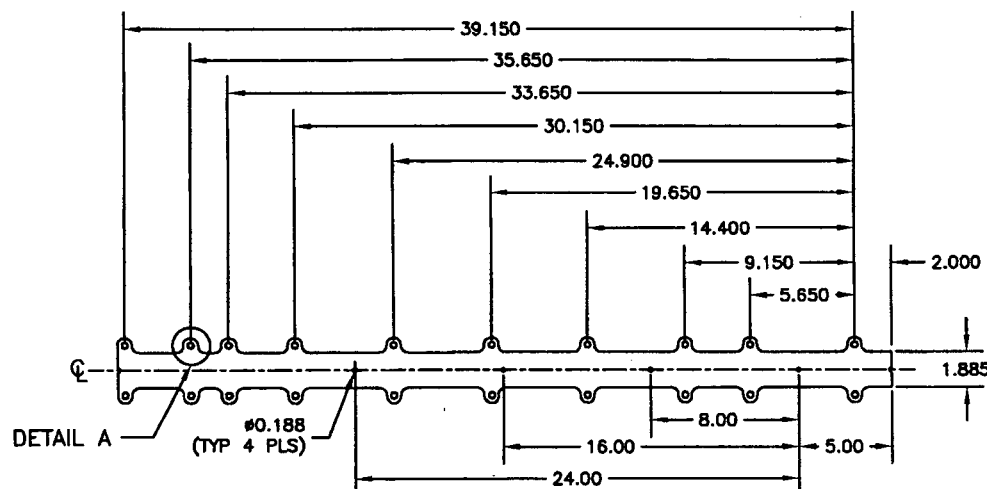
NOTE: Date & initial all entries

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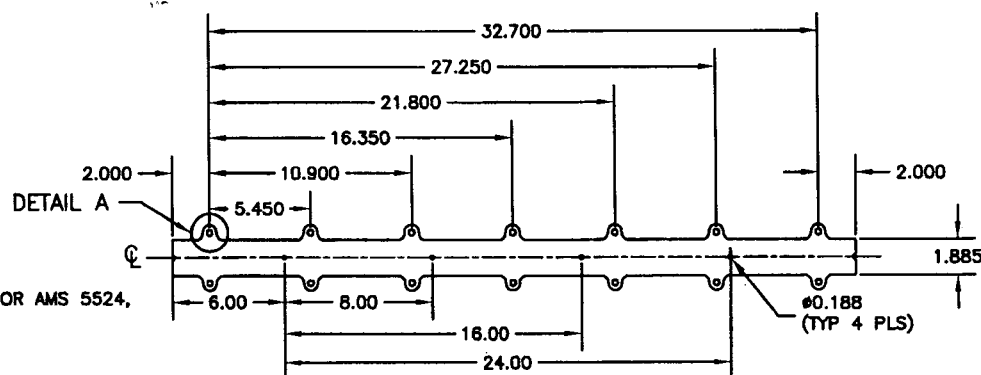
07.04.24

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | REV. B |
|--------------------|--------------------|--------------------------|--------------|
| CB | PH | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 2 OF 7 |
| <i>[Signature]</i> | <i>[Signature]</i> | D3535 | |
| DATE | TITLE | SCALE | |
| 07.04.17 | WEARSHOE | 1:10 | |



D3535-15F FLAT PATTERN

D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN

D3535-21 BEND DETAIL

NOTES

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Dart Aerospace Ltd

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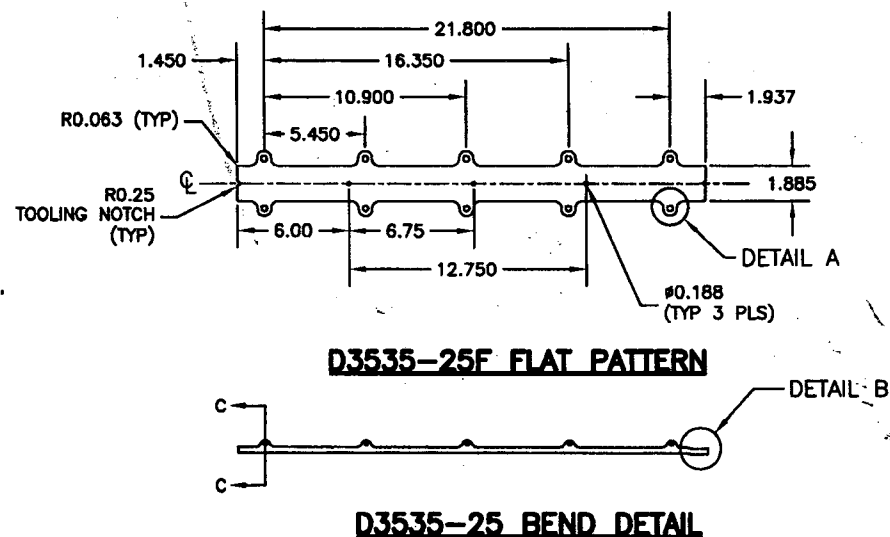
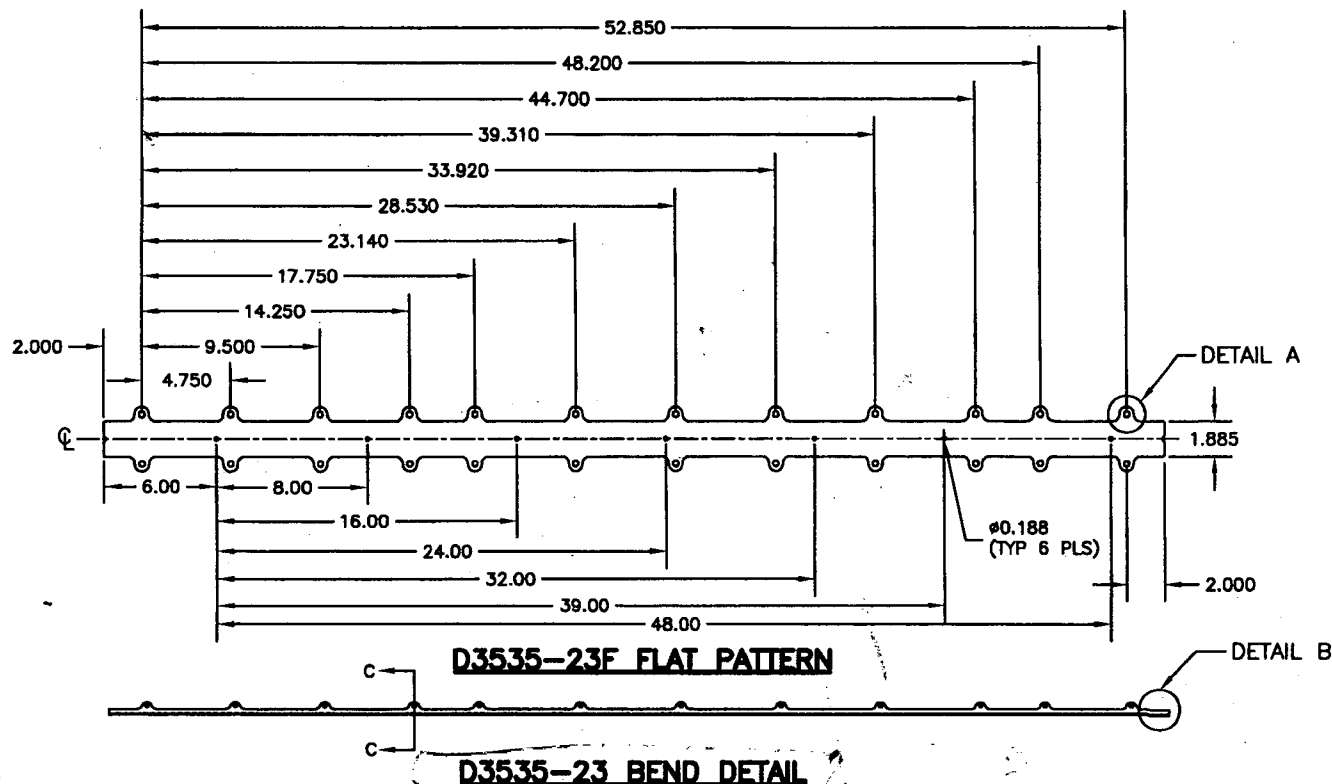
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74508

DART

RELEASED

07.04.24

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|---------|----------|--------------|-------|--------------------------|
| DESIGN | CB | DRAWN BY | PH | DART AEROSPACE USA, INC. |
| CHECKED | PH | APPROVED | PH | PORT HADLOCK, WA |
| DATE | 07.04.17 | TITLE | D3535 | WEARSHOE |
| | | SCALE | 1:10 | |
| | | SHEET 3 OF 7 | | |
| | | REV. B | | |

Dart Aerospace Ltd

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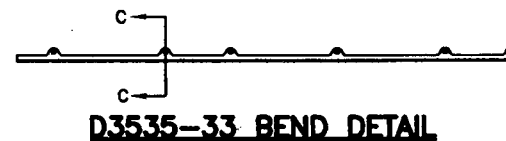
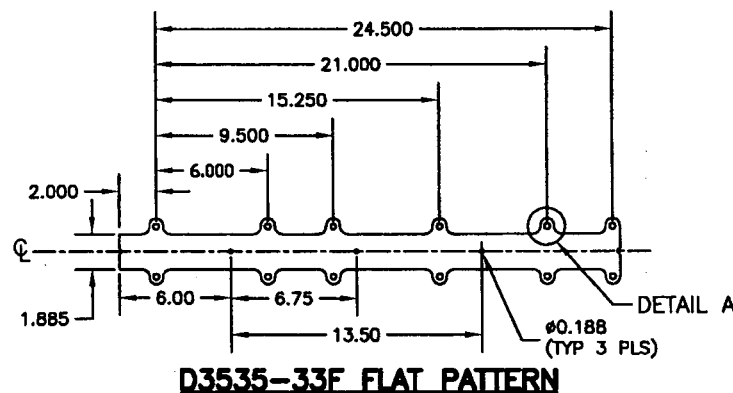
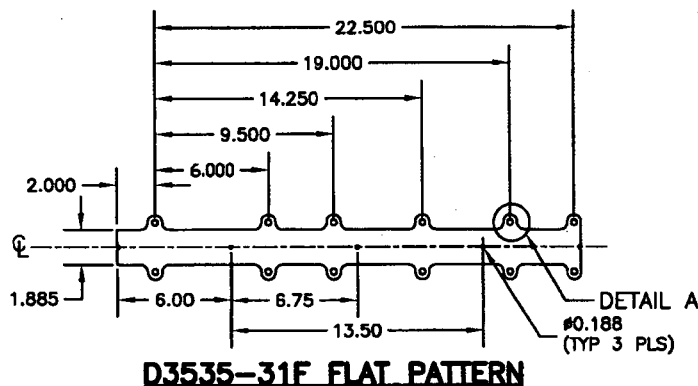
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NOTE: Date & initial all entries

DART

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| DESIGN CB | DRAWN BY AM | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3535 |
| DATE 07.04.17 | TITLE WEARSHOE | REV. B SHEET 4 OF 7 |
| | SCALE 1:10 | |

RELEASED
07.04.24



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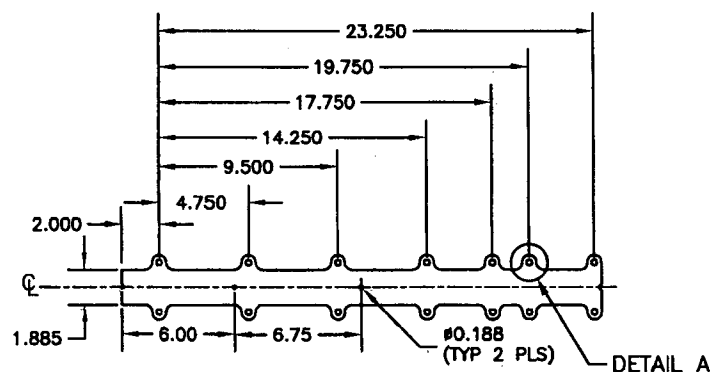
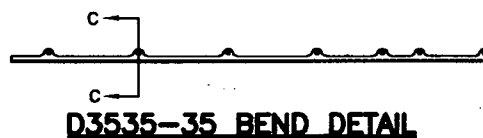
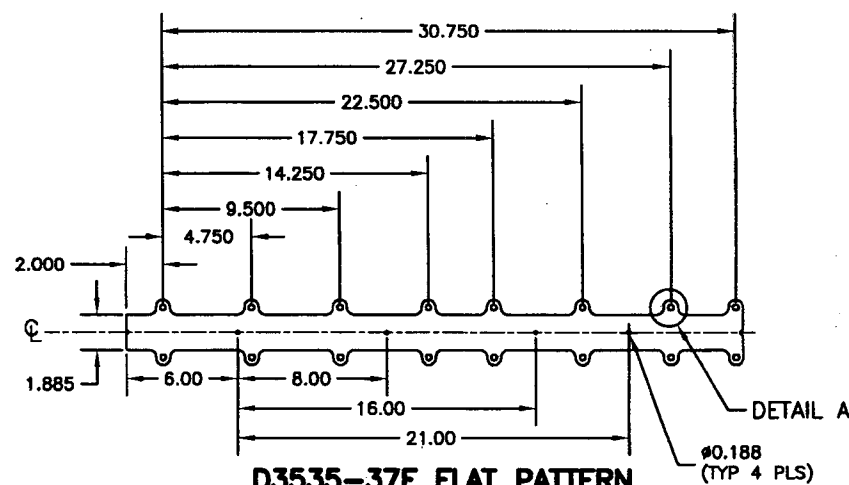
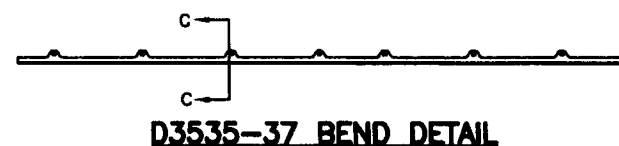
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

74508

DARTRELEASED
07.04.24**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

| | | | | |
|---------|--------------------|-------------|--------------------|--------------------------|
| DESIGN | C.B. | DRAWN BY | PH | DART AEROSPACE USA, INC. |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | PORT HADLOCK, WA |
| DATE | 07.04.17 | DRAWING NO. | D3535 | REV. B |
| | | TITLE | WEARSHOE | SHEET 5 OF 7 |
| | | SCALE | 1:10 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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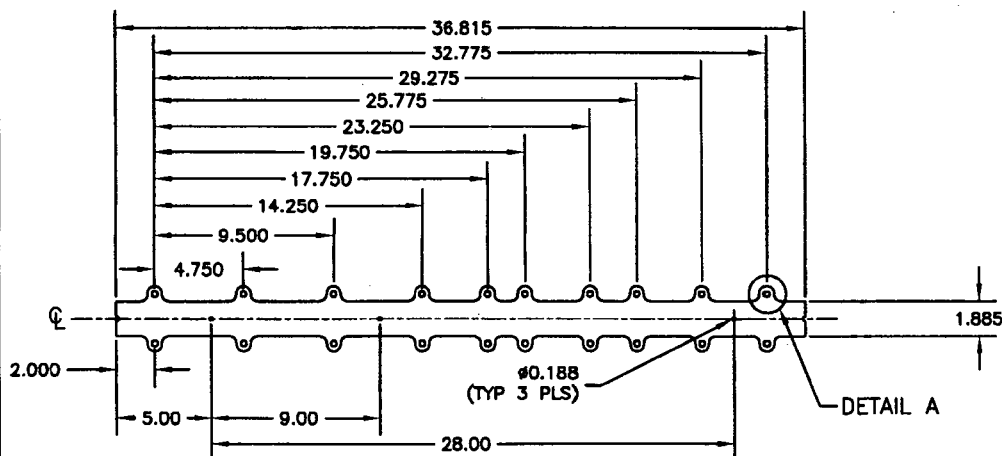
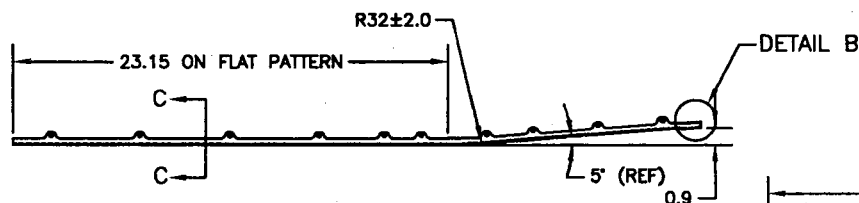
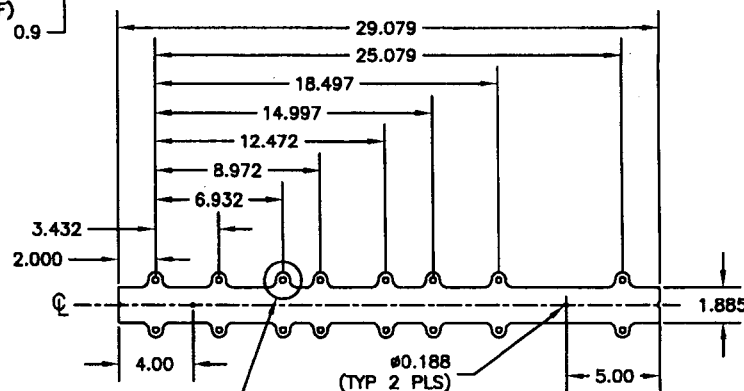
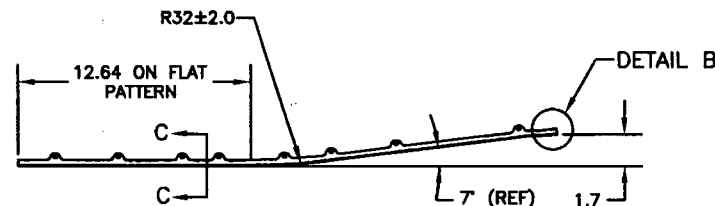
NOTE: Date & initial all entries

74508

DART

RELEASED

07.04.14

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

| | | | | |
|---------|----------|-------------|--------|--------------------------|
| DESIGN | CB | DRAWN BY | PH | DART AEROSPACE USA, INC. |
| CHECKED | | APPROVED | | PORT HADLOCK, WA |
| DATE | 07.04.17 | DRAWING NO. | D3535 | REV. B |
| TITLE | WEARSHOE | SHEET | 6 OF 7 | SCALE |
| | | | | 1:10 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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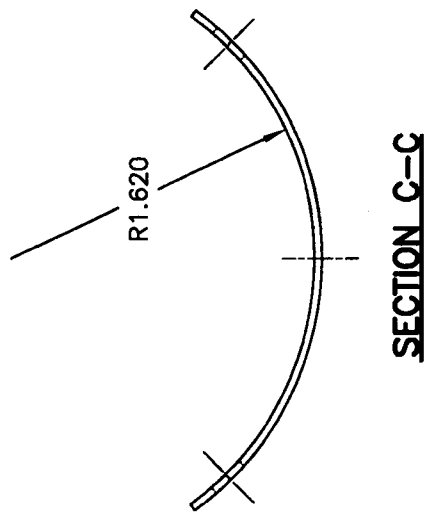
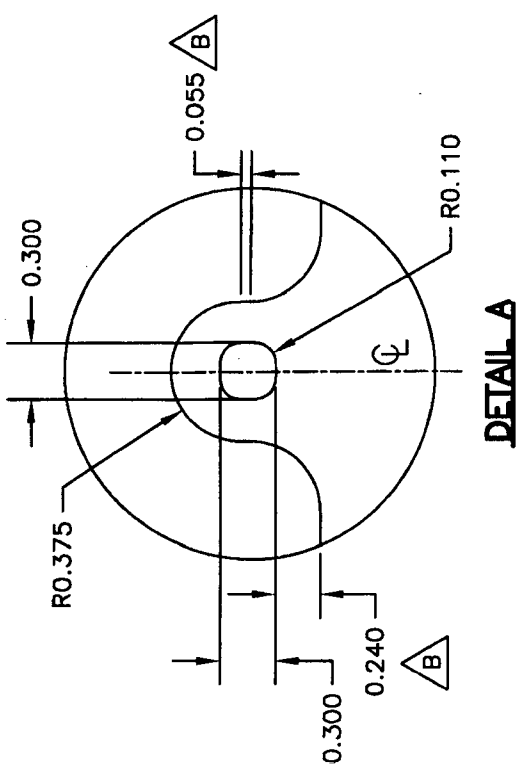
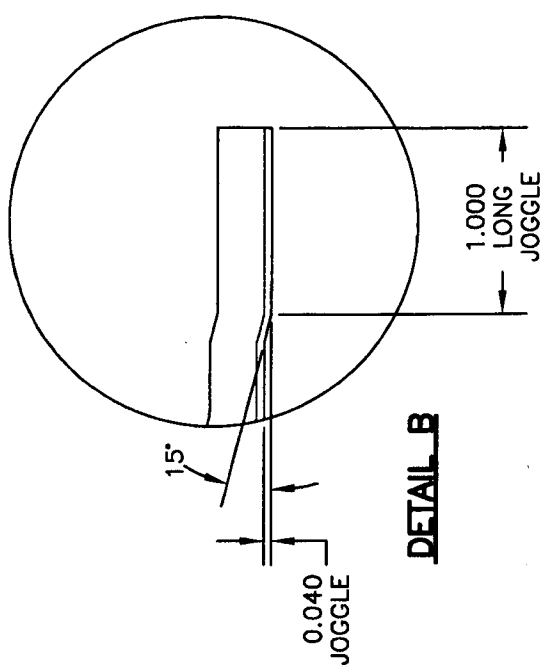
NOTE: Date & initial all entries



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|---------------------|-----------------------|--|------------------------|
| DESIGN CB | DRAWN BY PH | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. D3535 | REV. B SHEET 7 OF 7 |
| DATE 07.04.17 | | TITLE WEARSHOE | SCALE 1:1 |

RELEASED

07.04.24



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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries